

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-018661**Date Inspected:** 19-Nov-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** ShangHai, China**CWI Name:** Tian Lei**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

Summary of Items Observed: On this date Caltrans OSM Quality Assurance(QA) Inspector, DJ Shin was present during the times noted above for observations relative to the work being performed.

**Bay 2**

This QA Inspector observed the following work in progress for Bay 2.

ZPMC was using the Flux Core Arc Welding (FCAW) process.

ZPMC QC is identified as Zhu Lin.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

Components: Segment Assembly

PCMK: SEG3020K-361

Welder: 062708

WPS-B-T-2233-TC-U5-F

PCMK: SEG3020K-108

Welder: 066763

WPS-B-T-2233-TC-U5-F

PCMK: SEG3020K-362

Welder: 045240

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WPS-B-T-2233-TC-U5-F

PCMK: SEG3020K-101

Welder: 067888

WPS-B-T-2233-TC-U5-F

PCMK: SEG3020K-049

Welder: 045227

WPS-B-T-2233-TC-U5-F

PCMK: SEG3020K-382

Welder: 066733

WPS-B-T-2233-TC-U5-F

PCMK: SEG3020K-011

Welder: 207465

WPS-B-T-2233-TC-U5-F

PCMK: SEG3020K-055,056

Welder: 048696

WPS-B-T-2232-3

PCMK: SEG3020K-391,392

Welder: 045227

WPS-B-T-2232-3

Components: Grillage Plate

PCMK: SA7512-001-038

Welder: 066421

WPS-B-T-2233-TC-U5-F

PCMK: SA7512-001-052

Welder: 066443

WPS-B-T-2233-TC-U5-F

PCMK: SA7512-001-066

Welder: 066734

WPS-B-T-2233-TC-U5-F

Components: Longitudinal Diaphragm

PCMK: LD3051-001-035,037

Welder: 045209

WPS-B-T-2233-TC-U4b-F

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This QA inspector performed Magnetic Particle Testing (MT) and Visual Inspection (VT) of approximately 15 % of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The member(s) is/are identified as follows; VP3014 and VP3015, for item number 1 of NWIT tracker document # 07420

### Bay 7

This QA Inspector observed the following work in progress for Bay 7.

ZPMC was using the Flux Core Arc Welding (FCAW) process.

ZPMC QC is identified as Liu Chuan Gang.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

Components: Barrier Rail

PCMK: W2-SB10-038-112~114

Welder: 215189

WPS-B-T-2132-3

PCMK: W2-SB9-069-126~131

Welder: 062447

WPS-B-T-2132-3

PCMK: W2-SB10-034-112~114

Welder: 051246

WPS-B-T-2132-3

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



### Summary of Conversations:

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No relevant conversations

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Shin,DJ	Quality Assurance Inspector
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<b>Reviewed By:</b>	Carreon,Albert	QA Reviewer
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